Work Order ID 71117

Thursday, June 23, 2011 11:04:07 AM

Item ID: D2535 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Spring

Start Date: 6/23/2011 **Start Qty:** 100.00 **Cust Item ID:**

Required Date: 7/4/2011 **Req'd Qty:** 100.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** CL **Date:** 11/06/23 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2535	Rev A								
100	PURCHASING	0.00							
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 14354 ☐Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring					CL	11/06/23	100	
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	**Memo**	0.00							
Packaging	Ensure Material Release Note is attached					6/1/5		100	
120	QC6- Inspect dimensions to drawing	0.00				counter			
QC	**Memo**	0.00				(100)			
Quality Control	Check dims to dwg					QS019			

6/07/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 71117

Thursday, June 23, 2011 11:04:07 AM

Item ID: D2535 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Spring

Start Date: 6/23/2011 **Start Qty:** 100.00 **Cust Item ID:**

Required Date: 7/4/2011 **Req'd Qty:** 100.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 504	0.00				100			
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/7/11

11-07-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:04:03 AM

Work Order ID: 71117

Parent Item: D2535

Parent Item Name: Spring

Start Date: 6/23/2011 **Required Date:** 7/4/2011

Start Qty: 100.00 **Required Qty:** 100.00

Comments: IPP A□99.04.19□New Issue (From hand written IPP)□□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P Spring		Purchased	No			100	Each	0.0000	1	100	100	6/27/11	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

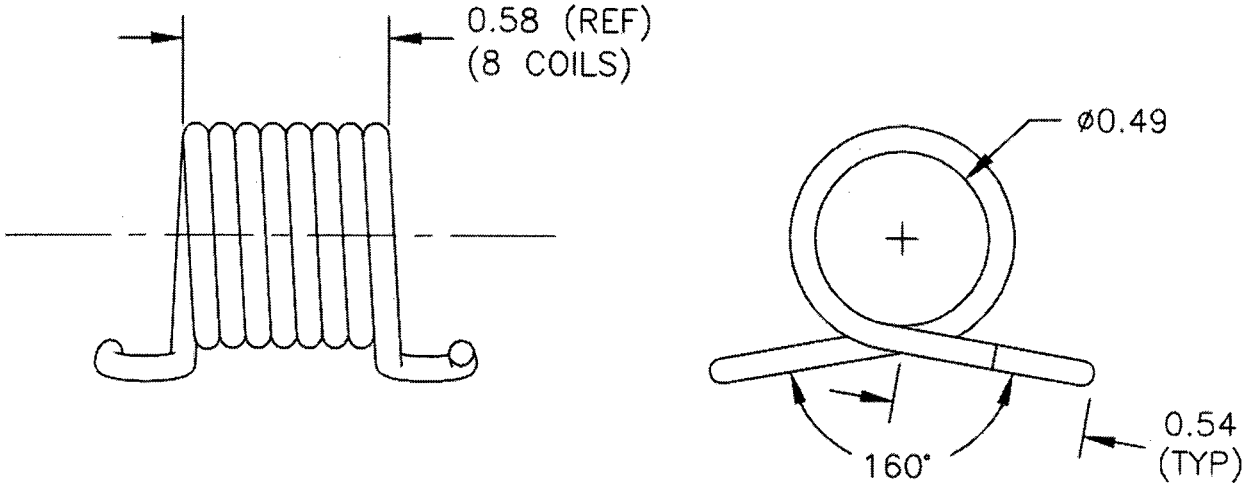
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	RF		
CHECKED: KE	APPROVED: DM	DRAWING NO.: D2535	REV. A SHEET 1 OF 1
DATE: 99.04.08		TITLE: SPRING SPEC CONTROL	SCALE: 2:1
A	99.04.08	NEW ISSUE	

DART

QA COPY ISSUED

RELEASED
99.05.11 KE



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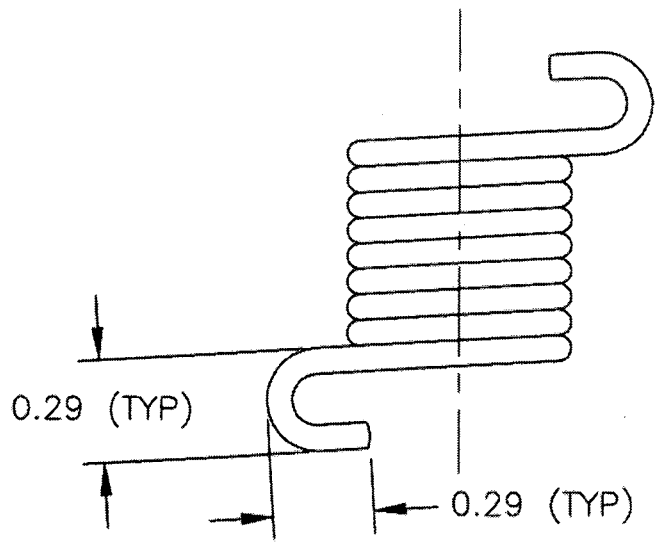

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)
MATERIAL: AISI STAINLESS STEEL Ø0.070
POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14354

Purchase Order Date 6/23/2011
PO Print Date 6/23/2011

Order From : VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	866 230 5312	**Requisition Nbr**	
Vendor Fax	866 230 5338	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED 6/23/2011

Line Nbr	Reference / Revision ID / Vendor Part Number	Description / Mfg ID	Req Date / Taxable	Req Qty / Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	7/4/2011 Yes	100.00 Each	FedEx PI collect	$4.5600	$456.00

Special Inst: AS PER DWG D2535 REV. A
B71117
VICTORY SPRING: 0.070 SS TORSION SPRING

PO Total: **$456.00**

CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1 **Change Date:** 6/23/2011

VICTORY SPRING
convenient. consistent. correct.

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

PACKING SLIP

22745

BILL TO:

Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

SHIP TO:

DATE	ORDER No.		SHIP VIA
4-Jul-11	PO14354		Fedex 151793240

QUANTITY	DESCRIPTION	UNIT	AMOUNT
100	D2535P Torsion Spring		

GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

VICTORY SPRING
convenient. consistent. correct.

2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 7/4/2011
PART/DRAWING #: D2535P	PO # PO14354
SPRING DESCRIPTION: Torsion	QUANTITY: 100

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	per previous orders
Coil I.D.	0.490	0.5	
Coil O.D.			
Number of Coils	8 ref	7.9	
Free Length			
Helix	RHW	yes	
End type	per dwg.	yes	
Deburr End			

COMMENTS

8 11/07/06

Mill Certificate attached: yes
Material Heat Number: 35771

Inspected by: *Jeremy Burrowes*

VICTORY SPRING
convenient. consistent. correct.

2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 7/4/2011
PART/DRAWING #: D2535P	PO # PO14354
SPRING DESCRIPTION: Torsion	QUANTITY: 100
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03	

PROPERTIES:

Chemical

Carbon:	(C)	0.056
Chromium:	(Cr)	18.110
Copper:	(Cu)	0.400
Manganese:	(Mn)	1.580
Molybdenum:	(Mo)	0.410
Nickel:	(Ni)	9.200
Nitrogen:	(N)	0.040
Phosphorus:	(P)	0.031
Silicon:	(Si)	0.460
Sulphur:	(S)	0.001

Physical

Size:	0.072"
Tensile:	254,000 / 258,000
Hardness:	
Heat #	35771

Certified by: *Jeremy Burrowes*

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.